

D206-642-641

Dart Aerospace Ltd.

Date: Friday, 1/25/2008 10:36:17 AM  
 User: Kim Johnston

## Process Sheet

11

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKIDTUBE LH 206A/B  
 Job Number : 36951  
 Estimate Number : 10801  
 P.O. Number :  
 This Issue : 1/25/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D206642611  
 First Issue : 1/1 Type : LANDING GEAR Drawing Number : N/A  
 Previous Run : 36176 Drawing Revision : L  
 Material :  
 Due Date : 3/10/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : 08 01 25  
 Comment : Est Rev:B 05.10.27 Revised pick list KJ/EC  
 Est Rev:C 07-12-05 ECN 1080p Rev:L DD verified by:

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-611 CHG003

08 04 29 08.02.27

2.0

36951A

FLOAT SKIDTUBE HIGH GEAR 206 A/B



Comment: Sub-Component FLOAT SKIDTUBE HIGH GEAR 206 A/B

D206-642-641 B 36951A

scf

3.0

D206651041

206 A/B GHW Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

1 D206-651-041 GHW Kit Batch: 34773

4.0

D2652

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 D2652 Bushing

8X B374538X B3874508 04 25

5.0

D26651

Saddle, LH Fwd Aft Out



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2665-1 Saddle 3580308 04 25 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

Date: Friday, 1/25/2008 10:36:17 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE LH 206AB

Job Number: 36951

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D26661

Saddle, LH, Fwd,Aft, In



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2666-1 Saddle

36188

7.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

10 D2712 Set Screw

34628

8.0

D2884

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2884 Saddle Spacer

35497

9.0

D2885

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2885 Saddle Spacer

37372

10.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3396-3 Spacer

AB6336

11.0

AN3C36A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 AN3C36A Bolt

M16541

8/4/25 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: FLOAT SKIDTUBE LH 206A/B

Job Number: 36951

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

MS21250 03004

HIGH STEEL BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

HIGH STEEL BOLT

batch M12277

13.0

D36721

PHENOLIC WASHER



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

PHENOLIC WASHER

batch 34470

14.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN4C6A Bolt M106519

15.0

AN5C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C7A Bolt M19185

16.0

AN5C11A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C11A Bolt M157013

17.0

AN5C32A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C32A Bolt M15746

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 36951

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batc

1 AN5C35A Bolt M107557

19.0

AN5C13A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

bolt

batch M107615

20.0

AN6C44A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batc

2 AN6C44A Bolt M107685

21.0

AN3C41A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

batch M107463

22.0

AN960C10L

washer



Comment: Qty.: 30.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick:

Qty Part Number Description Batch

30 AN960C10L Washer M107321

23.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 AN960C416L Washer M107008

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 36951

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN960C516L Washer M103344

*[Signature]*

25.0

AN960C616

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960C616 Bolt M19185

*[Signature]*

26.0

MS210433

Nut



Comment: Qty.: 17.0000 Each(s)/Unit Total : 17.0000 Each(s)

Pick:

Qty Part Number Description Batch

17 MS21043-3Nut M107288

*[Signature]*

27.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21043-4Nut M107101

*[Signature]*

28.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS21043-5Nut M106763

*[Signature]*

29.0

MS210436

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

M107376

*[Signature]*

8/14/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE LH 206A/B

Job Number: 36951

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 ms21043-6 Nut

30.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

batch M107715

31.0

D36831

INSERT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

batch 36315

32.0

D36727

PHENOLIC WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PHENOLIC WASHER

batch 35522

33.0

D36725

PHENOLIC WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

PHENOLIC WASHER

batch 35521

34.0

D36723

PHENOLIC WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

PHENOLIC WASHER

batch 34471

35.0

MS27039C105

SCREW



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

SCREW

batch M106874

8/4/20 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE LH 206A/B

Job Number: 36951

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*08/04/09 AL*

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-611

Location: *B*

PPP Rev: *Rev C*

*JS 08/04/09 (AL)*  
*08/05/01 JF*

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*CMF 08-04-30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

Cell

Date: Friday, 1/25/2008 10:36:52 AM  
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# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 36951A  
Estimate Number : 10803  
P.O. Number :  
This Issue : 1/25/2008 S.O. No. :  
Prsht Rev: : NC  
First Issue : / / Type : LANDING GEAR  
Previous Run : 36178A  
Written By :  
Checked & Approved By : 1/25/08 01 25  
Comment : Est Rev:B 05.11.15 Added washers for aft cap, wearshoes and ring EC  
Est Rev:C 06-05-31 Revised steps JLM  
Est Rev:D 07-02-22 Added SS Wearplates & Gaskets JLM  
Est Rev:E 07-12-06 ECN 1080p DD verified by:  
Drawing Name : FLOAT SKIDTUBE HIGH GEAR 206 A/B  
Part Number : D206642641  
Drawing Number : D3288 REV F U/R  
Project Number : N/A  
Drawing Revision : F  
Material :  
Due Date : 3/10/2008 Qty: 1 Um: Each  
1/25/08 01 25  
"UNDER REVIEW"

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D206-642-641 CHG003		
2.0	D2620	Bent 206 Skidtube
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2620 3" OD Bent Tube B 341693 ① M 8-3-26		
3.0	D2647	Cap
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2647 Fwd Cap B 34775 BE B-3-26		
4.0	D32861	Doubler
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3286-1 Doubler B 33895 ② M 8-3-29		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36951A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr FWD edge of tube,grind bending marks.

2-Remove ridge on inside of fwd edge of tube as per Dwg D3288.

3-Weld Fwd Cap as per Dwg D3288,Grind to obtain proper fit

A/R AL ROD

Batch:

*M106330/M106762 BE 08-03-26*

4-Grind welds flush to cap on top surface only.

5-Cut Aft end as per Dwg D3288 from front of tube then deburr

6-Remove inner indexing ridge on aft end as per Dwg d3288

7-Open holes for aft cap as per Dwg D3288 using Dt8025

8-Drill pilot holes using DT8818

9-Insert D3286-1 doubler using DT8732 & DT8879 ,then locating doubler off the  
D3286-1 doubler ,leave Dt8732 for added support

3/16" holes cleco

10-Drill D3286-1 doubler rivet holes in tube using #40 drill,spot drilling doubler at the same time.

11-Working from center out,drill #30 holes into D3286-1 Doubler.cleco each hole after its drilled,Verify angle of holes to accomodate rivet heads.

12-Remove 3/16" clecos only and open GHW holes to .500" as per Dwg D3288.

13-Remove D3286-1 doubler,identify orientation,deburr then attach to W/O

14-Remove indexing edge as per Dwg D3288.

15-C'sink rivet holes as per Dwg D3288.

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*8-08/03/31*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 36951A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q M 08-04-01 (1)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 08-04-01

9.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)

Pick:

Qty Part Number

Description Batch

52 CR3212-4-04

Rivet

MU7008

(52) 11 8-4-1

10.0

D3289041

Float Web (206A/B)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3289-041 Float Web

D32782

(1) 11 8-4-1

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Holes to finished size as per DWg.D3288.Deburr.

2-Locate, install and rivet doublers as per Dwg D3288. Micro-shave rivets as required.

3-Bond web in place as per Dwg D3288 & QSI 015.

A/R Sikaflex-291

M105535

Sikaflex expire date:

8-7-1

Start: 11:00

Time:

11:20 2:00

Finish: 8-4-2

Time:

8:00 AM

(Adhere for 12 hours)

11 8-4-1

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8-08/04/02 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 36951A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube using program D3288 as per Dwg D3288. Install drop pins in cross bolt spacer holes to maintain web position.

EL 8-4-2

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes for wearplates using D3288-T2 as per Dwg D3288, then open to Ø0.297". (without cutting fluid)

DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)

2-C'sink X-bolt holes.

3-Debur

X  
745

15.0

D2649

Crossbolt Spacer



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

9 D2649 Crossbolt spacer

37329

BE 08/04/07

16.0

D32751

Crossbolt Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 D32751-1 Crossbolt spacer

34619

BE 08/04/07

17.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-3

Spacer

35048

BE 08/04/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 36951A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

18.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3288. Remember to back drill each hole before welding the other side. Use aluminum rod.

A/R Aluminum Rod M 106330 BE 08/04/07

2-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3288. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required

A/RSS Rod NONE BE 08/04/15

3-Grind welds flush to Fwd cap on top surface only.

4-Grind cross bolt welds flush as per Dwg D3288. Masking Tape access to inside of the skidtube

5-Counterbore 5/16" x 0.750" deep using DT8747, except 8th cross bolt hole from Aft end, as per Dwg D3288.

PD

8-4-10

SL 8-4-15

19.0

~~QC 10~~

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

23.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-04-24

30 min  
22/04/2008  
S.086 11.50  
#1 319.2  
#2 336951A  
#3 D206642641

W/O: 36951A

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/04/25	#13	C'core at location indicated on attached DWG Does not need to be performed PERMANENT CHANGE	RJ	08.04.25	1	RJ Q55042 08.04.25	08/04/25

Part No: D206-642-641 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries



Date: Friday, 1/25/2008 10:36:52 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36951A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3415-041 Nut Plate B33842

JSJ

25.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivet M106825

\*

JSJ

26.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CR3212-4-03 Rivet M115918

JSJ

27.0

ALS71032130

Insert



Comment: Qty.: 64.0000 Each(s)/Unit Total : 64.0000 Each(s)

Insert

Batch: M1105855

JSJ

28.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D3415-041 Nut Plate as per Dwg D3288 ,Install with LPS-3

A/R LPS-3 Batch: M105005

2-Install inserts Dwg D3288. Use a drop of Sikaflex inside insert holes

A/R Sikaflex-291 M1107804

Sikaflex expire date: 08/10

JSJ

08.04.24 (X)

JSJ 08-01-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:36:52 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36951A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP  
Inserts & Nut plate

NA

00/01/24

30.0

D353515

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
WEARSHOE  
Batch: 1336653

NA

31.0

D353521

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
WEARSHOE  
Batch: 1331991

NA

32.0

D353535

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
WEARSHOE  
Batch: 1337625

NA

33.0

D353541

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
WEARSHOE  
Batch: 1331993

NA

34.0

D353615

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
GASKET  
Batch: 1339641

NA

35.0

D353621

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
GASKET  
Batch: 1337351

NA

08-04-24 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 1/25/2008 10:36:52 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36951A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

D353635

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B38183

JS

37.0

D353641

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B31997

JS

38.0

D35371

WEARPAD



Comment: Qty.: 7.0000 Each(s)/Unit Total: 7.0000 Each(s)

WEARPAD

Batch: B37292

JS

39.0

D35373

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARPAD

Batch: B33881

JS

40.0

AN3C4A

BOLT



Comment: Qty.: 66.0000 Each(s)/Unit Total: 66.0000 Each(s)

BOLT

Batch: 40x1-7M107736 (46x1-7M107715)

JS

41.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

batch M106516

JS

42.0

AN960C10L

washer



Comment: Qty.: 78.0000 Each(s)/Unit Total: 78.0000 Each(s)

Pick:

Qty Part Number Description Batch

78 AN960C10L Washer M107376

JS

08-04-24

(K)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:36:52 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36951A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

D36831

INSERT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

batch B36319

*JP*

44.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring B33949

*JP*

45.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt M104936

*JP*

46.0

AN960C416

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

washer

batch: M100993

*JP*

47.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap B36184

*JP*

48.0

MS27039C105

SCREW



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

SCREW

batch M1107008

*JP*

08-04-24

*(X)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Friday, 1/25/2008 10:36:52 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36951A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

49.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

✓ 2-Install wearshoes/wearpads & Gaskets as per Dwg D3288.

✓ 3-Install Ring on Nut Plate as per detail F & Dwg D3288.

✓ 4-Spray inside tube with LPS-3 on both sides of web M105005

5-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive.

✓ A/R Sikaflex-291 M07804

Sikaflex expire date: 08/10

6-Coat all exposed fastners with LPS Procyon, remove any excess on powder coat

✓ with MEK Degreasser.

A/R LPS Procyon Batch: M104251

HS  
08-04-24 (XU)

HS 08-04-24 (XU)

50.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/04/25 (XU)

51.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-641

Location: 70

PPP Rev: PPP 36951

AS 08/04/29 (XU)

52.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/01 (XU)

Job Completion



MF 08-04-30

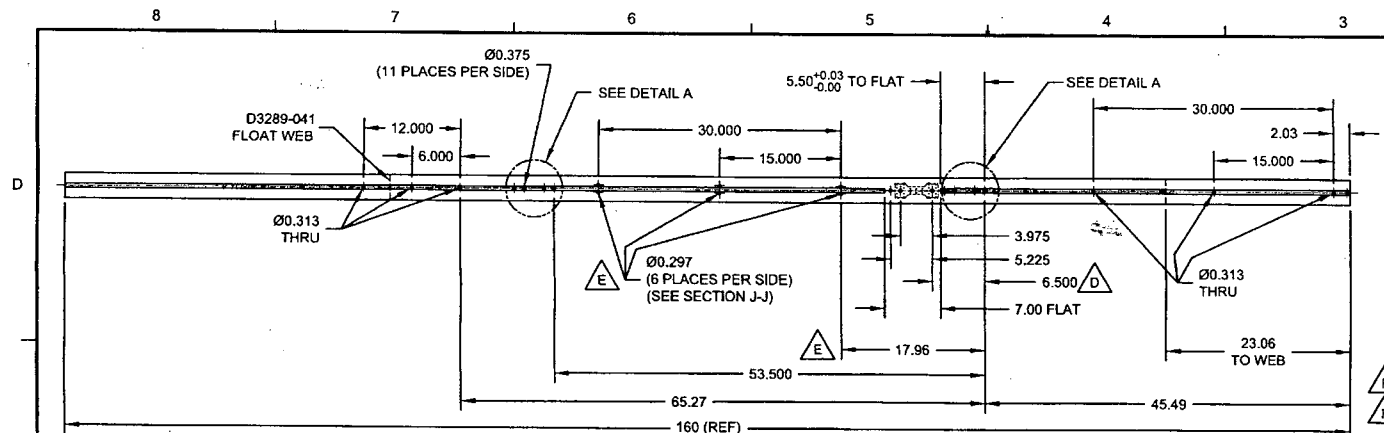
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

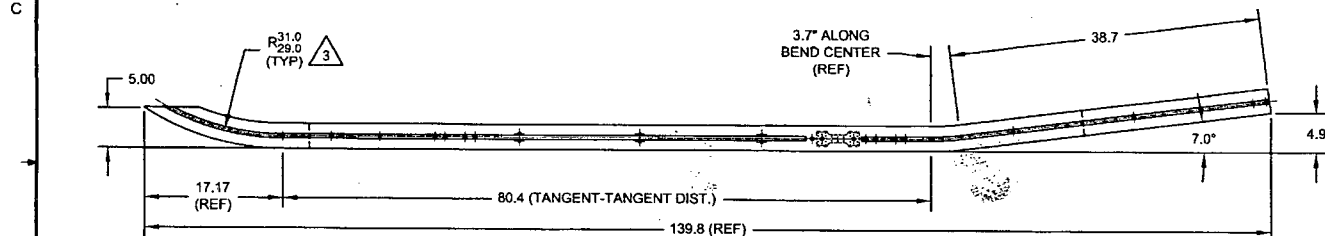
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

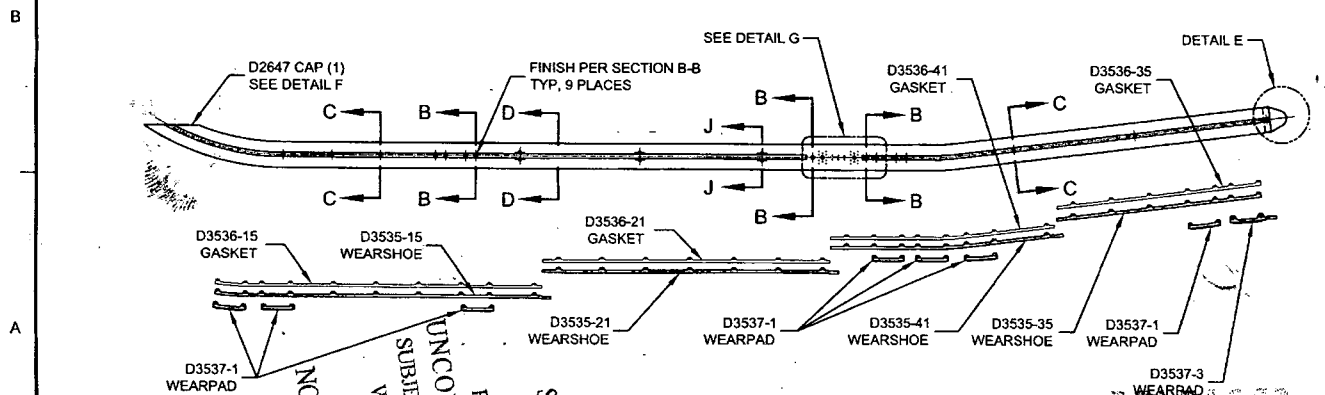
NOTE: Date & initial all entries



**D3288-041 DRILLING/WEB ASSEMBLY DETAIL**



**D3288-041 BENDING DETAIL**



**D3288-041 WELDING DETAIL/SKIDTUBE ASSEMBLY**

Qty	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2646	AFT CAP
1	D2647	CAP
9	D2849	CROSS BOLT SPACER
6	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
12	D3683-1	INSERT
64	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C5A	BOLT
1	AN8C4A16	WASHER
78	AN8C4A10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
12	MS27039C1-05	SCREW (or AN3C3A BOLT)
2	NAS1518H3L	WASHER

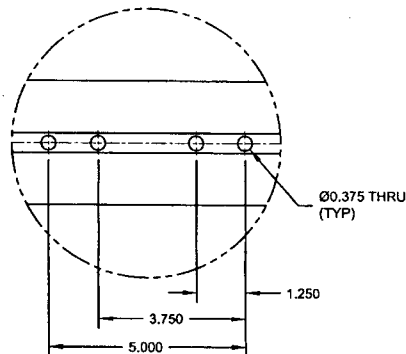
**GENERAL NOTES:**

1. FINISH: - ACID ETCH, ALDINE ASSEMBLY PER DART QSI 005 4.1  
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
2. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
3. DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
4. BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. ALL HOLES DRILLED ON CENTERLINES.
6. DRILL Ø0.297 HOLES FOR D3683-1 INSERTS BEFORE FINISH. INSTALL D3683-1 INSERTS AFTER FINISH.
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/291.
8. TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
9. UNITS: INCHES UNLESS OTHERWISE NOTED.
10. WELDING: PER DART QSI 004.

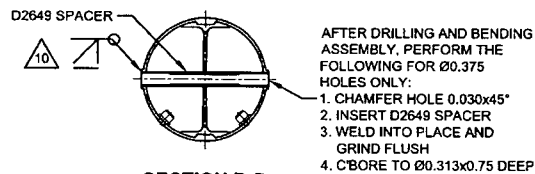
F	SUBSTITUTE FLOAT BAG INSERT W/SPEC CTRL DWG WAS ALS7-1032-130; IS NOW D3683-1	DC	07.11.21
E	MID-FLOAT HOLES WERE MOVED 2.00" FWD AND ROTATED INBOARD AND OUTBOARD BY 17° INSERTS ARE NOW INSTALLED AT THESE LOCATIONS	MB	07.09.14
D	DIMENSIONS ADDED	DC	07.06.04
C	NEW INSERTS, SS WEARSHOES AND GASKETS	PH	06.12.19
B	CHANGE INSERTS	CP	05.03.18
A	NEW ISSUE	CP	04.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	JP		
DRAWN	DL		
CHECKED	PL		
MFG. APPR.	PL		
APPROVED	PL		
DE APPR.	PL		
DATE	07.11.21		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3288 TITLE SKIDTUBE ASSEMBLY REV. F SHEET 1 OF 2 SCALE 1:15 COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

NO. 368514  
WORK ORDER  
SHIP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO A  
WITHOUT NOTICE

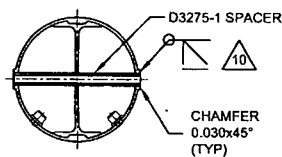
RELEASED  
07.12.19/14



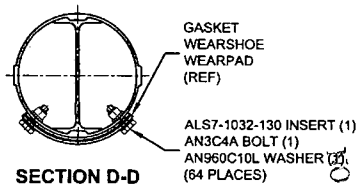
**DETAIL A: DRILL DETAIL**



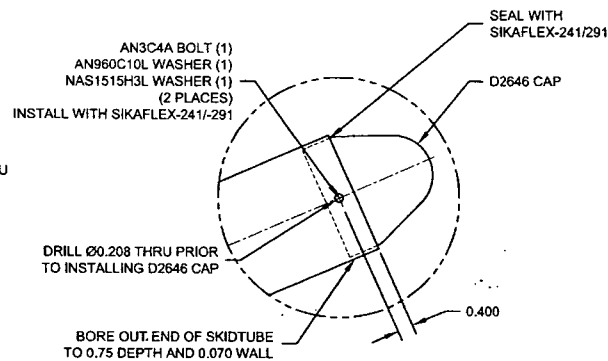
**SECTION B-B**  
FOR Ø0.375 HOLES ONLY  
(TYP, 9 PLACES)



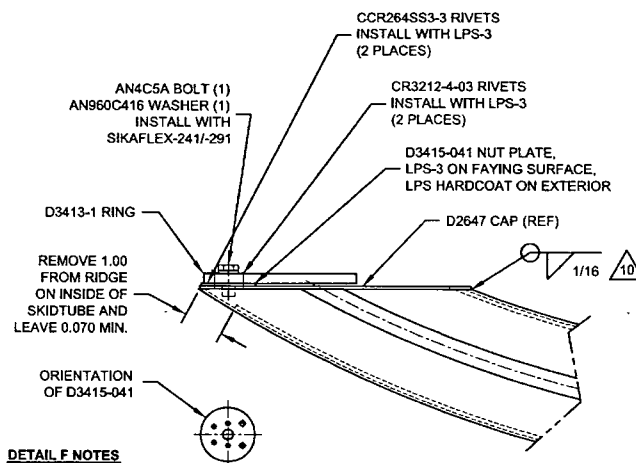
**SECTION C-C**  
FOR Ø0.313 HOLES ONLY  
(TYP, 6 PLACES)



**SECTION D-D**  
FOR WEARSHOES INSTALL ONLY  
(TYP, 32 PLACES)



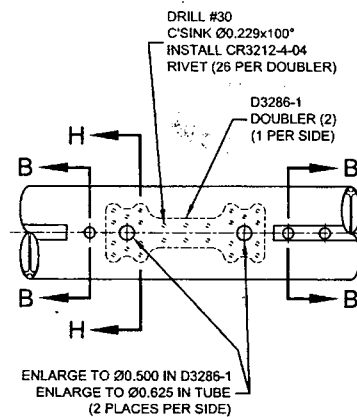
**DETAIL E**



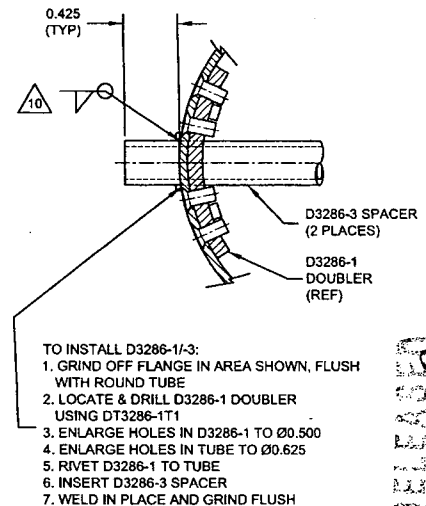
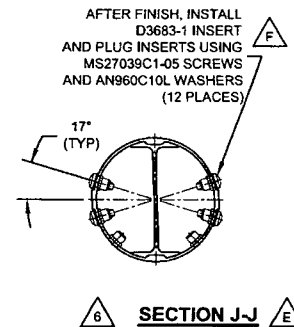
**DETAIL F NOTES**

1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D2647 (TRIM AS NECESSARY)
  4. WELD D2647 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

**DETAIL F: END FINISHING DETAIL**



**DETAIL G**  
SCALE 1:5



**SECTION H-H**  
NOT TO SCALE

DESIGN	7	<b>DART AEROSPACE LTD</b>	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. F
MFG. APPR.	BC	D3288	SHEET 2 OF 2
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	SKIDTUBE ASSEMBLY	1:3
DATE	07.11.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

WORK ORDER  
00-20951A  
SUBJECT TO  
NOTICE  
UNCONTROLLED COPY  
RETURN TO  
ENGINEERING  
SHOP COPY  
NO COPY



**Peter Hum**


---

**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** April 25, 2008 12:33 AM  
**To:** 'Peter Hum'  
**Cc:** 'Chris Provencal'  
**Subject:** RE: D206-642-641 float skidtube and D206-642-141 skidtube

There is no reason to c'bore that hole on -641.  
 OK to sign off a deviation for existing production and update the drawing for the future.

David

---

**From:** Peter Hum [mailto:phum@dartaero.com]  
**Sent:** Thursday, April 24, 2008 9:09 AM  
**To:** David Shepherd  
**Cc:** 'Chris Provencal'  
**Subject:** D206-642-641 float skidtube and D206-642-141 skidtube

David,

Dan Paquette in landing gear noticed an inconsistency between the D206-642-641 float skidtube (D3288-041) and D206-642-141 skidtube (D2650-1):

- a) On D2650-1, the hole immediately forward of the 2 GHW holes that protrude out of the skidtube is NOT C'BORED (see attached)
- b) On D3288-041, the same hole IS C'BORED (see attached)

I did some digging with ChrisP and found out that we have a D206-651 GHW kit that uses the above hole. A D2711 pin goes thru at this location and I think a c'bore would NOT be necessary. Production has been making the D206-642-641 float skidtube WITHOUT the c'bore and it has been shipped to customers.

There is a few D206-642-641 in production, and they are wondering if this hole needs to still be c'bored because that was what they previously have been doing (this problem was only discovered now)

I think we should do the following:

- a) Allow the hole to be NOT C'BORED (i.e. sign a deviation)
- b) Update the drawing to remove the C'BORE

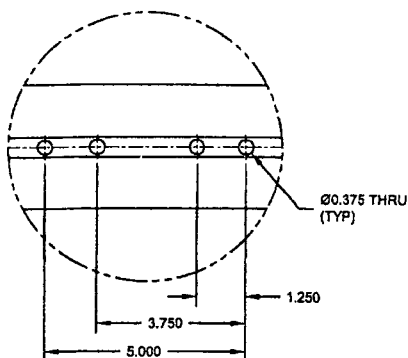
I don't think this will affect anything that has been shipped because the D2711 will still fit and perform as intended.

Is there a specific reason why the float skidtube needs the C'bore but not on the std. skidtube? (I think this detail was missed on the drawing updates of the D3288)

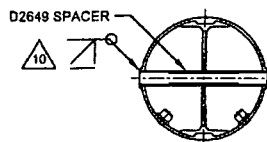
What do you think? Have I missed something?

Peter Hum  
 Mechanical Designer  
 Dart Aerospace Ltd.  
 1270 Aberdeen St.  
 Hawkesbury, ONT, K6A 1K7  
 Tel: (613) 632-5200  
 Fax: (613) 632-9311

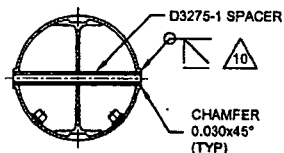
25/04/2008



**DETAIL A: DRILL DETAIL**



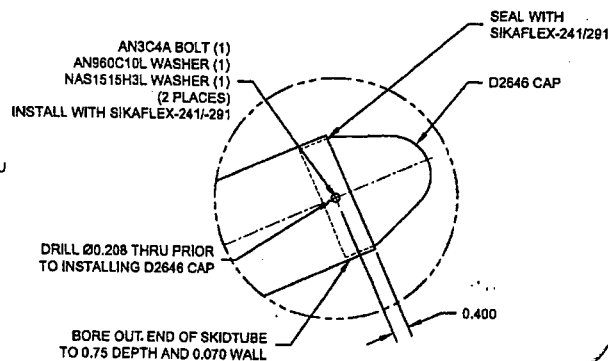
**SECTION B-B**  
FOR Ø0.375 HOLES ONLY  
(TYP, 9 PLACES)



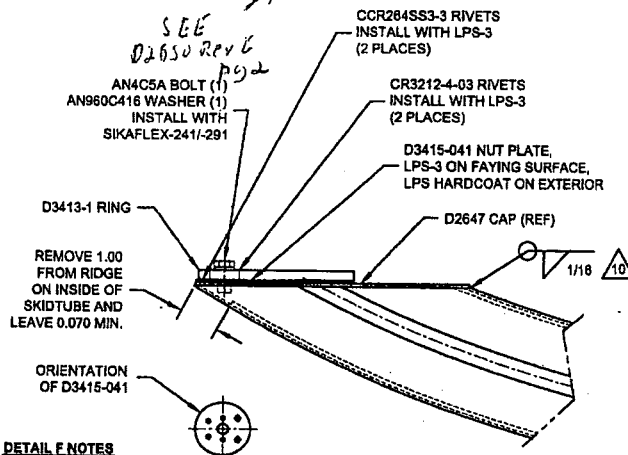
**SECTION C-C**  
FOR Ø0.313 HOLES ONLY  
(TYP, 6 PLACES)



**SECTION D-D**  
FOR WEARSHOES INSTALL ONLY  
(TYP, 32 PLACES)



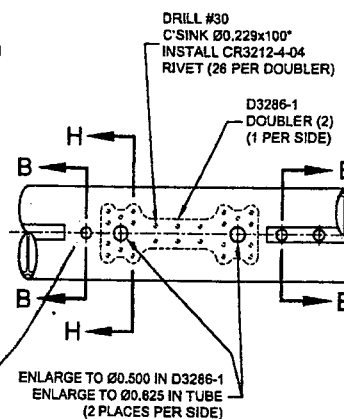
**DETAIL E**



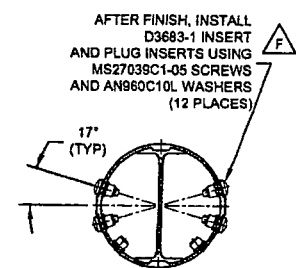
**DETAIL F NOTES**

- CUT TUBE LEVEL
  - REMOVE RIDGE ON FWD SIDE
  - LOCATE D2647 (TRIM AS NECESSARY)
  - WELD D2647 IN PLACE PER DART QSI 004
  - GRIND FLUSH
  - RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

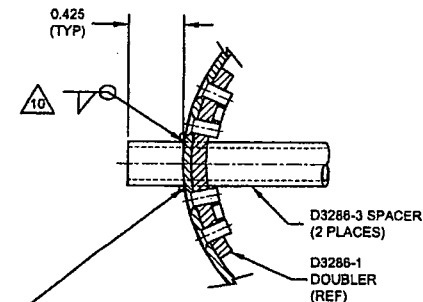
**DETAIL F: END FINISHING DETAIL**



**DETAIL G**  
SCALE 1:5



**SECTION J-J**



**SECTION H-H**  
NOT TO SCALE

- TO INSTALL D3286-1/3:
- GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
  - LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  - ENLARGE HOLES IN D3286-1 TO Ø0.500
  - ENLARGE HOLES IN TUBE TO Ø0.625
  - RIVET D3286-1 TO TUBE
  - INSERT D3286-3 SPACER
  - WELD IN PLACE AND GRIND FLUSH

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO. D3288	REV. F
MFG. APPR.	DC	SHEET 2 OF 2	
APPROVED	DC	SCALE	
DE APPR.	DC	SKIDTUBE ASSEMBLY	
DATE	07.11.21	1:3	

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